



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4931-1
Job Sheet 196477



Part No: D4931-1

Job Qty: 12 pcs

Part Name: Engine Fitting (for acft models B2 & previous)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/13/19

Job Tracking No:

Due Date: 7/15/19

Created By: Lorin Baltac

Type: Stock

Description:

Note: DWG REV A SHEET 1 IPP REV:A NEW ISSUE 13-09-05 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Doosan - 1	12 pcs	7/15/19	7/15/19	1.00	15.00	Doosan - 1	
110	QC 2	12 pcs	7/15/19	7/15/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	

DAS
5
9-89

DAS
5
9-89



Container No: S192072



Part: D4931-1

Job No: 196477

Serial No/Batch: S192072

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/19/19

120 QC 8	12 pcs	7/15/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	PML 14/06/20
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Packaging 3-2 - Stock - B4B	12 pcs	7/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC ST127
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	12 pcs	7/15/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89
Part Op 100 - (Doosan Lathe)Machine as per folio FB210 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - QC8- Inspect parts - second check) 130 - Identify as per dwg & Stock Location: _____)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M303R2.000	303 Round Bar 2"	3 ft (25 ea)	100-Doosan - 1	S/63533	33 1/4
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Doosan - 1	M303R2.000	3	16	0	
Part Specifications					
Specifications could not be found.					

Plex 6/13/19 11:38 AM Dart.Baltac.Lorin

DART AEROSPACE LTD		Work Order:	
Description: EAPS P2 Engine Fitting		Part Number:	D4931-1
Inspection Dwg: D4931	Rev: A	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.06 x 45°	+/-0.030 x +/-0.5°	1/16 x 45°			caliper	
0.362	+/-0.010	.366				
0.088	+/-0.010	.089				
0.08	+/-0.030	.065				
0.25	+/-0.030	.258				
0.50	+/-0.030	.5				
Ø0.063	+0.004/-0.001	.066				
0.125	+/-0.010	.128				
0.424	+/-0.010	.427				
0.315	+/-0.010	.31				
0.185	+/-0.010	.186				
37°	+/-0.5°	37°				
1.283	+/-0.010	1.288				
1.250	+/-0.010	1.25				
Ø0.472	+0.006/-0.001	.4765				
Ø0.670	+0.008/-0.001	.67				
0.500	+/-0.010	.509				
0.950	+/-0.010	.945				
Ø0.609	+0.008/-0.001	.612				
0.938	+0.000/-0.005	.936				
1.804 Ref	+/-0.010	1.813				
1-1/16-12 UN 2A	N/A				Nut	
M18 x 1.5 Thread	N/A				Go NoGo	
Wire Size 0.55	Max 1.099 ⁵ Min 1.093 ⁸	1.098				
Wire Size 0.040	Max 0.737 ⁸ Min 0.732 ³	.737				

Measured by:	<i>[Signature]</i>	Checked by:	<i>mmc</i>	QC Inspector:	
Date:	19/06/19	Date:	19/06/20	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.08.27	New Issue	KJ	<i>[Signature]</i>
B	16.05.30	Dimensions updated	KJ	<i>[Signature]</i>